



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
Fax 613 632-5246

D2940-1

Job Sheet 204290



Part No: D2940-1

Job Qty: 10 pcs *mk*

Part Name: Support



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 12/5/19

Job Tracking No:

Due Date: 1/10/20

Created By: Marie Lajeunesse

Type: Stock

Description:

Note: DWG D2940 REV D IPP C 02.11.26 Reformat; Added P/O KJ IPP Rev:D Added priming as per Rev B 07-04-30 JLM IPP E 08.03.19 Re-format Ec verified by DD IPP Rev:F 08-10-22 add qc14 DD verified by:EC IPP Rev:G 11.08.04 as per dwg rev.C DD ver:EC/IPP Rev.H 19.10.01 DWG revision (ECN 19-829) DP Verify DD

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
100	HAAS 4 Axis	6 pcs	1/10/20		2.00	14.29	HAAS - 1		
							HAAS - 2		
							HAAS - 3		
							HAAS - 4		
110	QC 2	6 pcs	1/10/20		0.00	0.00	QC 2 - 1		
							QC 2 - 12		
							QC 2 - 14		
							QC 2 - 17		
							QC 2 - 19		
							QC 2 - 2		
							QC 2 - 20		
							QC 2 - 22		
							QC 2 - 23		
							QC 2 - 25		
							QC 2 - 32		
							QC 2 - 33		
							QC 2 - 35		
							QC 2 - 39		
							QC 2 - 4		
							QC 2 - 40		
							QC 2 - 44		
							QC 2 - 45		
							QC 2 - 48		
							QC 2 - 49		
							QC 2 - 50		
							QC 2 - 51		
							QC 2 - 52		
							QC 2 - 57		
							QC 2 - 62		
							QC 2 - 63		



Container No: S253811



Part: D2940-1

Job No: 204290

Serial No/Batch: S253811

Revision: D

Inspector:

Exp Date:

Instructions: Various STC's

Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
CANADA
TEL : 1 613 632-5200
Email: sales@dartaero.com
www.dartaerospace.com

Date: 02/06/20

Plex 12/5/19 2:02 PM Dart.lajeunesse.marie

				QC 2 - 8	
				QC 2 - 66	
				QC 2 - 64	11/1. 2020/02/10
				QC 2 - 65	
				QC 2 - 5	
				QC 2 - 71	
				QC 2 - 73	
				QC 2 - 69	
120 QC 8	6 pcs	1/10/20	0.00 0.00	QC 8 - 12	
				QC 8 - 14	20/02/10
				QC 8 - 17	
				QC 8 - 20	
				QC 8 - 25	
				QC 8 - 3	
				QC 8 - 32	
				QC 8 - 33	
				QC 8 - 35	
				QC 8 - 39	
				QC 8 - 4	
				QC 8 - 44	
				QC 8 - 45	
				QC 8 - 49	
				QC 8 - 58	
				QC 8 - 8	
				QC 8 - 9	
				QC 8 - 68	
				QC 8 - 67	
				QC 8 - 1 (A)	
				QC 8 - 47	
				QC 8 - 40	
				QC 8 - 52	
				QC 8 - 23	
				QC 8 - 57	
				QC 8 - 76	
				QC 8 - 61	
130 Crosstubes - 2 - B4B	6 pcs	1/10/20	0.00 0.75	Crosstubes - 1 - B4B	
				Crosstubes - 2 - B4B	
				Crosstubes - 3 - B4B	
				Crosstubes - 4 - B4B	RD 20-2-7
140 QC 5	6 pcs	1/10/20	0.00 0.00	QC 5 - 10	
				QC 5 - 12	
				QC 5 - 17	
				QC 5 - 18	
				QC 5 - 19	
				QC 5 - 22	
				QC 5 - 24	
				QC 5 - 3	
				QC 5 - 43	
				QC 5 - 49	
				QC 5 - 51	
				QC 5 - 58	
				QC 5 - 68	
				QC 5 - 9	
				QC 5 - 50	
				QC 5 - 30	
				QC 5 - 40	
				QC 5 - 61	
				QC 5 - 81	
170 Packaging 3-1 - Stock - B4B	6 pcs	1/10/20	0.00 0.00	Packaging 3 - 1 - B4B	

				Packaging 3 - 2 - B4B	DAS
				Packaging 3 - 3 - B4B ✓	LG051 80
				Packaging 3 - 4 - B4B	9-89
				Packaging 3 - 5 - B4B	FEB 14 2020
				Packaging 3 - 6 - B4B	
				Packaging 3 - 7 - B4B	
				Packaging 3 - 8 - B4B	
				Packaging 3 - 9 - B4B	
				Packaging 3 - 10 - B4B	
				Packaging 3 - 11 - B4B	
				Packaging 3 - 12 - B4B	
				Packaging 3 - 13 - B4B	
				Packaging 3 - 14 - B4B	
				Packaging 3 - 15 - B4B	
				Packaging 3 - 16 - B4B	
				Packaging 3 - 17 - B4B	
				Packaging 3 - 18 - B4B	
				Packaging 3 - 19 - B4B	
				Packaging 3 - 20 - B4B	
				Packaging 3 - 21 - B4B	
				Packaging 3 - 22 - B4B	
				Packaging 3 - 23 - B4B	
				Packaging 3 - 24 - B4B	
				Packaging 3 - 25 - B4B	
				Packaging 3 - 26 - B4B	
				Packaging 3 - 27 - B4B	
				Packaging 3 - 28 - B4B	
				Packaging 3 - 29 - B4B	
				Packaging 3 - 30 - B4B	
				Packaging 3 - 31 - B4B	
				Packaging 3 - 32 - B4B	
				Packaging 3 - 33 - B4B	
				Packaging 3 - 34 - B4B	
				Packaging 3 - 35 - B4B	
				Packaging 3 - 36 - B4B	
180 QC 21 - SA	10 pcs	1/10/20	0.00 0.00	QC 21 - SA - 21 ✓	LG051
				QC 21 - SA - 70	
				QC 21 - SA - 53	
Part Op 100 - 1-Machine as per Folio FA079 Descriptions: 110 - (QC8- Inspect parts - second check) 120 - (QC8- Inspect parts - second check) 130 - Per note 9 on page 1 of dwg D2940, Prep inner concave surface of support and apply 3M Scotch-Weld as per dwg. 140 - (QC5- Inspect part completeness to step on W/O) 170 - (Identify as per dwg & Stock Location: _____) LOCATION : LG052 180 - (QC21- Final Inspection - Work Order Release)					DAS 21 FEB 14 2020
Job BOM					
Part / Item	Component Name	Quantity	Operation	Container	
DSK081	D2940-1 Turning Detail	3 pcs (.5 ea)	100-HAAS 4 Axis	5226363 = 5x	
Job Allocations					
Operation	Component Part	Required	Inventory	Allocated	
100-HAAS 4 Axis	DSK081	3	7	0	

Part Specifications					
Spec No	Description	Target/Tolerance	Limits	Type	Special Comments
1	3.250 Support	0.240Inches + 0.020 - 0.000	0.260 0.240		
2	3.250 Support	0.490Inches + 0.020 - 0.000	0.510 0.490		
3	3.250 Support	0.140Inches + 0.020 - 0.000	0.160 0.140		
4	3.250 Support	3.510Inches + 0.020 - 0.000	3.530 3.510		
5	3.250 Support	1.633Inches + 0.040 - 0.000	1.673 1.633		
6	3.250 Support	1.493Inches + 0.020 - 0.000	1.513 1.493		
7	3.250 Support	0.040Inches + 0.020 - 0.000	0.060 0.040		
8	3.250 Support	0.188Inches + 0.005 - 0.000	0.193 0.188		
9	3.250 Support	0.140Inches + 0.020 - 0.000	0.160 0.140		
10	3.250 Support	2.518Inches + 0.020 - 0.000	2.538 2.518		
11	3.250 Support	0.040Inches + 0.020 - 0.000	0.060 0.040		
12	3.250 Support	0.010Inches + 0.010 - 0.000	0.020 0.010		
13	3.250 Support	0.140Inches + 0.020 - 0.000	0.160 0.140		
14	3.250 Support	0.350Inches + 0.100 - 0.000	0.450 0.350		
15	3.250 Support	0.240Inches + 0.020 - 0.000	0.260 0.240		
16	3.250 Support	0.150Inches + 0.020 - 0.000	0.170 0.150		
17	3.250 Support	0.053Inches + 0.020 - 0.000	0.073 0.053		
18	3.250 Support	101.640Inches + 4.000 - 0.000	105.640 101.640		
19	3.250 Support	0.260Inches + 0.007 - 0.000	0.267 0.260		
20	3.250 Support	0.053Inches + 0.020 - 0.000	0.073 0.053		
21	3.250 Support	4.118Inches + 0.020 - 0.000	4.138 4.118		

Plex 12/5/19 2:02 PM Dart.lajeunesse.marie

DART AEROSPACE LTD		Work Order: 204290
Description: Ø Support		Part Number: D2440-1
Inspection Dwg: D2440-1 Rev: D		Page 1 of 1

FIRST ARTICLE INSPECTION DIMENSION SHEET

Dim	Min	Max	Go/No Go Gauge	Record Actual Dimensions				
				1	2	3	4	5
HAAS Section								
AA	0.140	0.190		.174	.172	.170	.175	.171
AB	0.040	0.060		.0419	.048	.045	.049	.047
AC	Ø 0.187	Ø 0.193		.190	.190	.190	.190	.190
AD	Ø 0.260	Ø 0.267		.263	.263	.263	.263	.263
AE	0.143	0.163		.158	.157	.153	.157	.158
AF	1.485	1.525		1.497	1.496	1.497	1.495	1.495
AG	3.510	3.530		3.524	3.520	3.520	3.520	3.520
AH	0.350	0.450		.410	.410	.410	.410	.410
AI	4.930	4.990		4.956	4.958	4.957	4.958	4.959
AJ	0.140	0.180		.154	.155	.161	.156	.156
AK	0.140	0.180		.171	.170	.168	.171	.167
AL	2.322	2.342		2.322	2.331	2.331	2.331	2.330
AM	0.040	0.100		.103	.105	.103	.105	.103
AN	0.040	0.060		.049	.048	.056	.052	.049
AO	0.140	0.160		.151	.150	.151	.151	.153
AP	R0.240	R0.260		.250	.250	.250	.250	.250
AQ	R0.053	R0.073		.063	.063	.063	.063	.063
AR	R0.053	R0.073		.063	.063	.063	.063	.063
AS	R0.240	R0.260		.250	.250	.250	.250	.250
AT	R0.470	R0.530		.500	.500	.500	.500	.500
AU	R0.920	R0.980		.950	.950	.950	.950	.950
AV								
AW								
AX								
AY								
AZ								
Ensure that Ø " bore is perpendicular to " bore within "								
Accept/Reject								

Measured by: <i>mal</i>	Date: 20/02/05
Audited by: <i>mal</i>	Date: 20/02/06
Preliminary Approval:	Date:

Rev	Date	Change	Revised by	Approved
A	08.04.24	New Issue	KJ/JLM	
B	12.07.31	Prototype revised to preliminary	KJ	

DART AEROSPACE LTD		Work Order: 204290
Description: Ø Support		Part Number: D2440-1
Inspection Dwg: D2440-1 Rev: D		Page 1 of 1

FIRST ARTICLE INSPECTION DIMENSION SHEET

Dim	Min	Max	Go/No Go Gauge	Record Actual Dimensions				
				16	27	08	49	110
HAAS Section								
AA	0.140	0.190		.170	.166	.168	.168	.167
AB	0.040	0.060		.046	.048	.047	.047	.047
AC	Ø 0.187	Ø 0.193		.190	.190	.190	.190	.190
AD	Ø 0.260	Ø 0.267		.263	.263	.263	.263	.263
AE	0.143	0.163		.155	.155	.155	.156	.155
AF	1.485	1.525		1.495	1.502	1.500	1.501	1.499
AG	3.510	3.530		3.521	3.522	3.523	3.521	3.521
AH	0.350	0.450		.400	.400	.412	.400	.410
AI	4.430	4.990		4.458	4.459	4.460	4.446	4.446
AJ	0.140	0.180		.158	.159	.159	.157	.157
AK	0.140	0.180		.165	.174	.170	.171	.172
AL	2.322	2.342		2.322	2.322	2.331	2.330	2.330
AM	0.040	0.100		.106	.106	.105	.104	.105
AN	0.040	0.060		.055	.051	.052	.051	.052
AO	0.140	0.160		.150	.153	.154	.155	.155
AP	R0.240	R0.260		.250	.250	.250	.250	.250
AQ	R0.053	R0.073		.063	.063	.063	.063	.063
AR	R0.053	R0.073		.063	.063	.063	.063	.063
AS	R0.240	R0.260		.250	.250	.250	.250	.250
AT	R0.470	R0.530		.500	.500	.500	.500	.500
AU	R0.920	R0.980		.950	.950	.950	.950	.950
AV								
AW								
AX								
AY								
AZ								
Ensure that Ø " bore is perpendicular to " bore within "								
Accept/Reject								

Measured by: mm/M.M. DAS 64	Date: 20/02/05
Audited by: [Signature] 9-89	Date: 20/02/06
Preliminary Approval:	Date:

Rev	Date	Change	Revised by	Approved
A	08.04.24	New Issue	KJ/JLM	
B	12.07.31	Prototype revised to preliminary	KJ	

250
 260
 510
 650
 150
 150
 950
 450

Entered: _____ Date: _____



WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No. _____

Route update only ☐

Job: <u>204290</u> Part No. <u>12940-1</u>		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐		DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Eng. (Non-AW) ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Engineering ☐ Water Jet ☐ Supplier Quality ☐					
Date : _____		Sequence # : _____		QTY Affected : _____			MRB (QSI042) DAS 51 <i>SM</i> 9-89 <i>20/02/07</i>		
Description Work Order Deviation				Disposition				Completed By	
Part number Engraving was Machine (CNC) on part				Acceptable to Engrave Part number with Mantronic					
								Lead hand / Supervisor	
								QC / QA Coordinator	
Root Cause Operator ☐ Manufacturing Process ☐ Equip/Tooling ☐ Handling/Preservation ☐ Material ☐ Product Improvement ☐ Process Improvement ☐ Human Factors ☐		FAULT CATEGORY ☐ Pressure/Forced ☐ Bending ☐ Crushing ☐ Cracks ☐ Crimp/Kink/Ripple/Wave/Twist ☐ Marks/Chatter ☐ Mislabeled ☐ Contamination ☐ Misaligned/off center ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Incomplete/Unclear Instructions ☐ Drill Holes ☐ Fit/Function ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain Direction ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set/Set-up ☐ Positioned Wrong ☐ Outside Tolerance ☐ Drawing ☐ Finish ☐ Part Lost/Missing ☐ Misread							
Other/Details:									